

Date: Tuesday, 16/09/2008 1:22:01 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 42026		
Estimate Number	: 10710		
P.O. Number	:	Part Number	: D32111
This Issue	: 16/09/2008 S.O. No. :	Drawing Number	: D3211 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 40467	Material	:
Written By	:	Due Date	: 30/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.9.16</u>		
Comment	: Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now on Waterjet 06-10-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.4753 sf(s)/Unit Total : 14.7525 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063)Identify as D3211-1
 Batch: 108415 B 8-9-17

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3211
 Dwg Rev: A1
 Prog Rev: A1

B 8-9-17

2-Deburr if necessary

B 8-9-17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/09/18 (X)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

Done at step 2.2
S 01/11/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 1:22:01 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42026

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



PT 2

Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 08/09/19 (9)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/09/19 (9)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-h 08/09/19

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15
320
8:45

M-h 08/09/20

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/9/20 SP

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 212

AS 08/09/20 (19)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/23

Job Completion


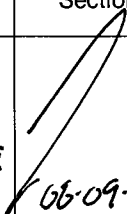

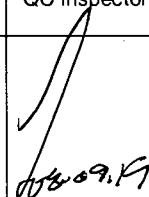


MF 08-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3211-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42026</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/19	6	1 part sieve broke with new die for 2024		Scrap & destroy No Replace.	SB 08/09/19	 06-09-19		 08-09-19

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3211	SHEET 1 OF 2
DATE		TITLE	SCALE
03.09.03		BRACKET	1:3
A	03.09.03	NEW ISSUE	
A1	03.12.05	CHANGE ALL DIM FROM TO 0.125	

RELEASED
03.09.05

D3211-1 BRACKET

MACHINE PER DRAWING FILE "D3211-A2.DWG"

CHECK PER TEMPLATE D3211-1T1

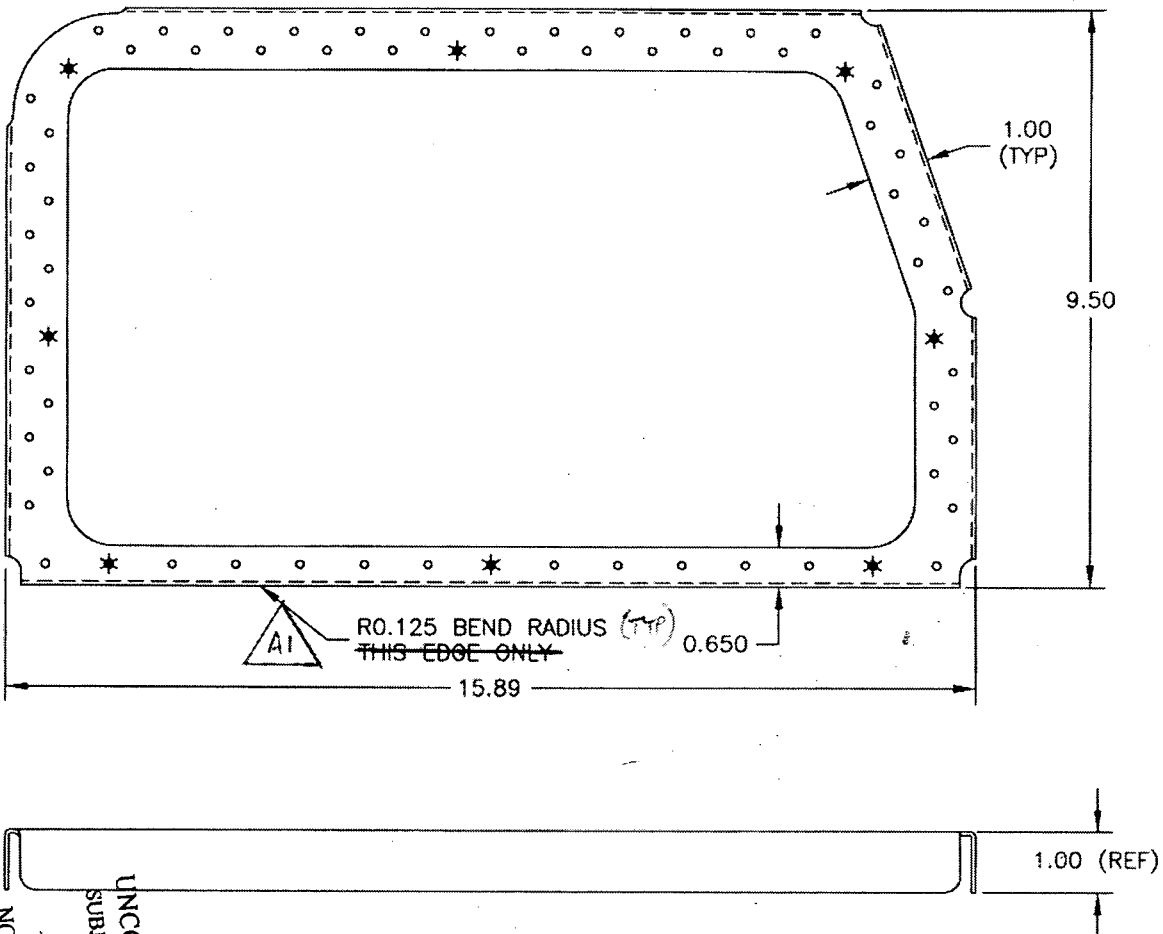
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

USE MINIMUM BEND RADIUS OF ~~0.188"~~ EXCEPT WHERE INDICATED ~~0.125"~~ 0.125"

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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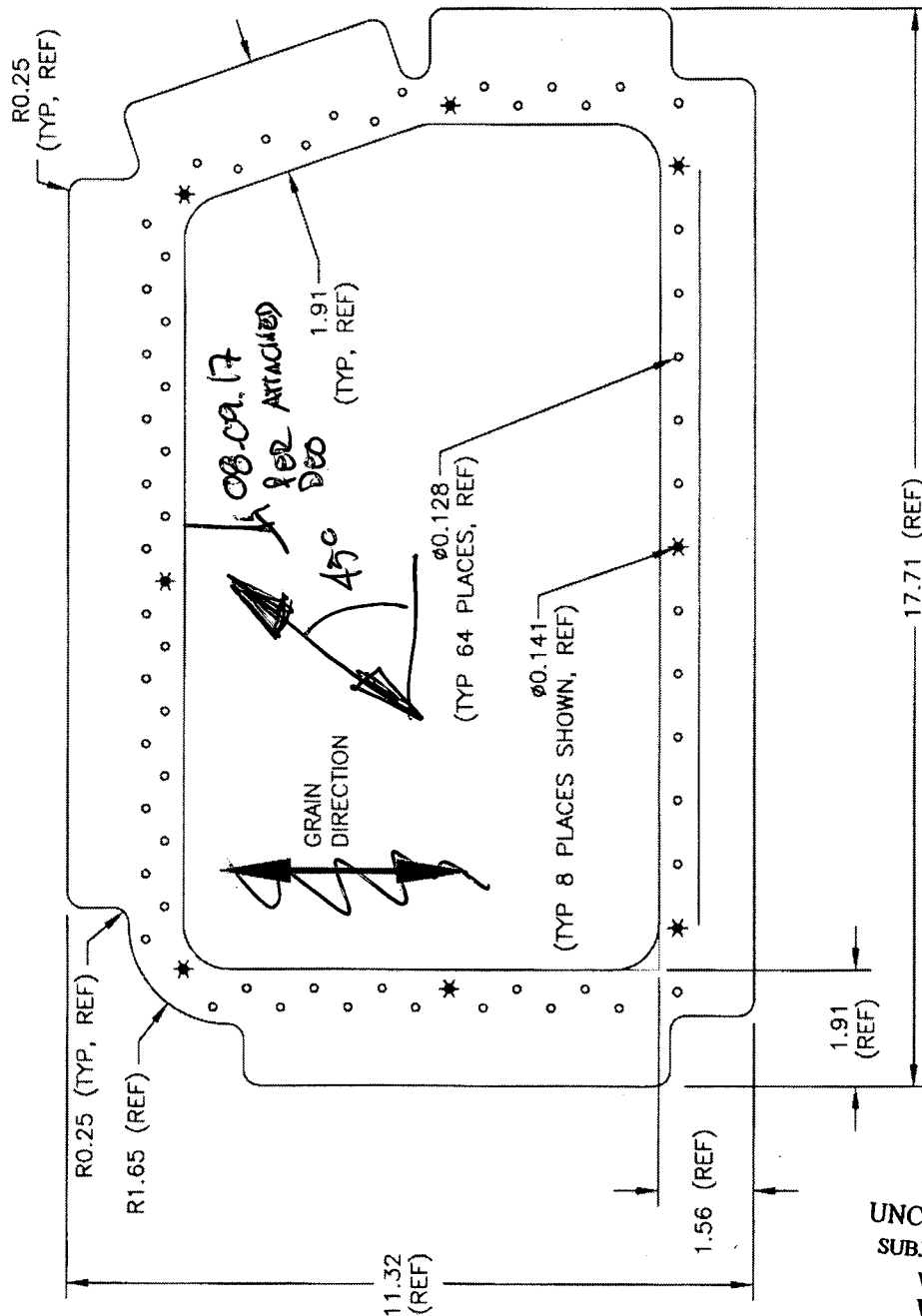
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3

RELEASED
03.09.05

D3211-1 FLAT PATTERN



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WORK ORDER
NO. 42026

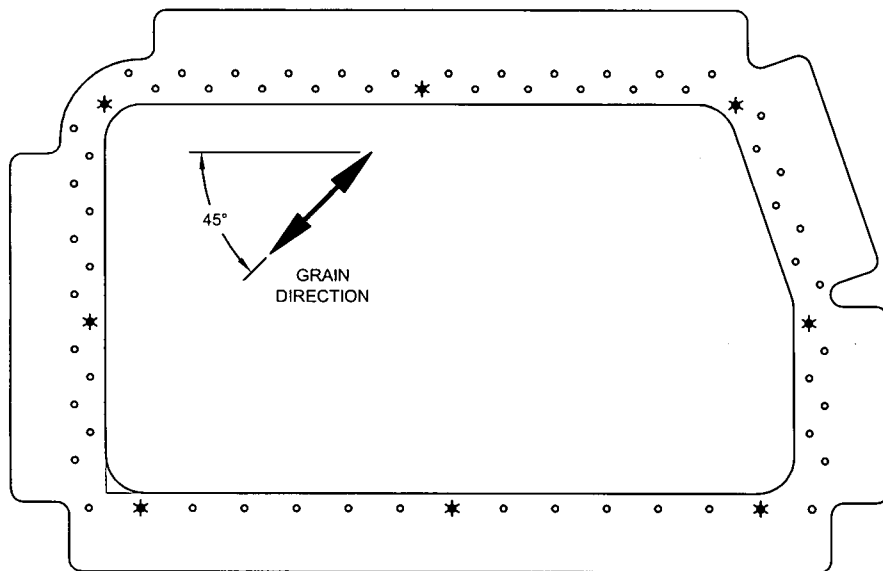
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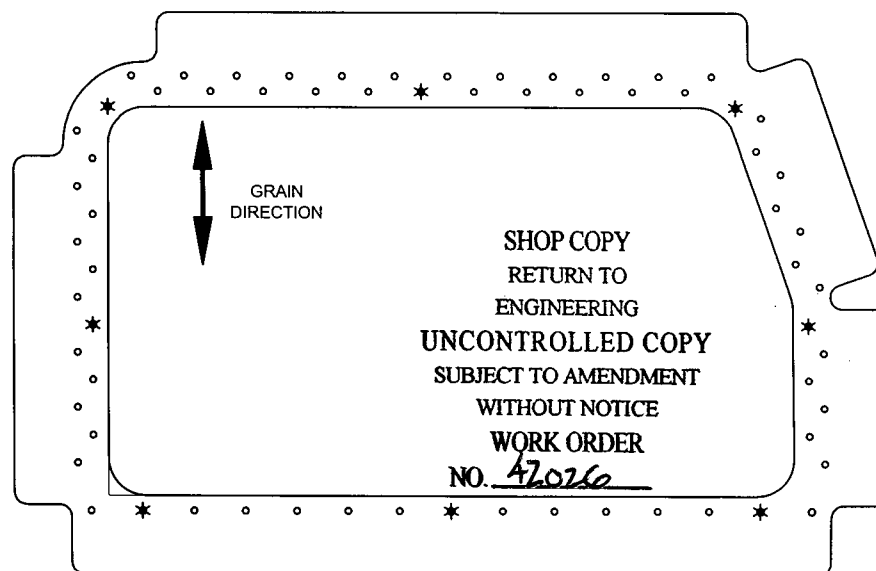
DRAWING NO. D3211	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3211-A-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS		CHECKED	MFG. APPR.		APPROVED	DE APPR.	
DATE 08.09.12		DATE	DATE		DATE	DATE	

SHEET 2 MODIFY GRAIN DIRECTION AS SHOWN BELOW TO FACILITATE BENDING (SEE CAR 08-001).

IS:



WAS:



REFERENCE ONLY

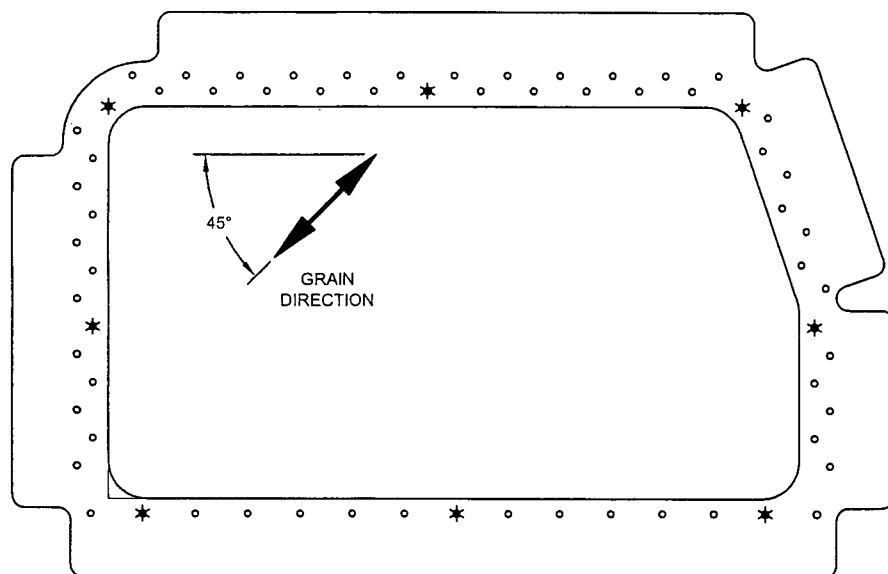
ALL OTHER INFORMATION REMAINS UNCHANGED

MS
08.09.17

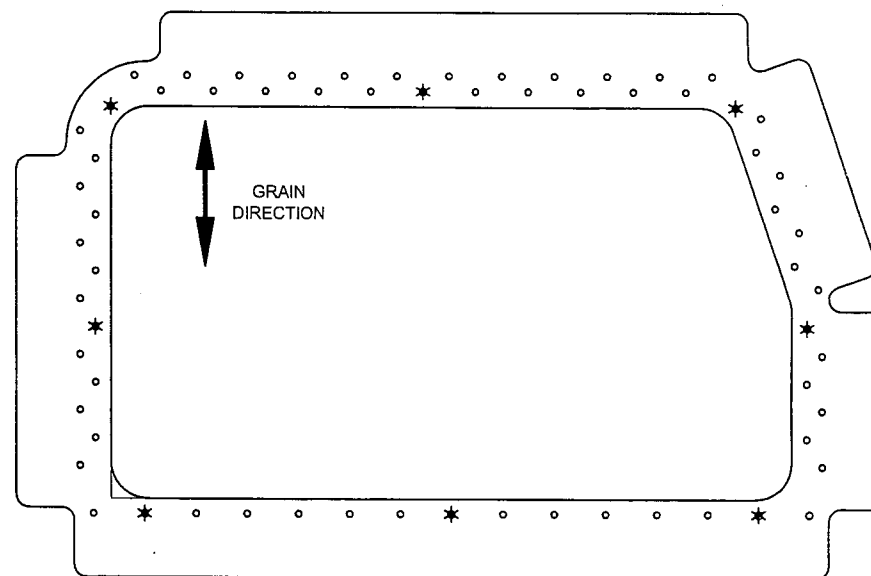
DRAWING NO. D3211	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3211-A-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.09.12	DATE 08.09.12	DATE 08.09.12	DATE 08.09.12		DATE 08.09.12		

SHEET 2 MODIFY GRAIN DIRECTION AS SHOWN BELOW TO FACILITATE BENDING (SEE CAR 08-001).

IS:



WAS:



RELEASED
[Signature]

ALL OTHER INFORMATION REMAINS UNCHANGED